

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006775**Date Inspected:** 17-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Chen Chih Chien and Liu Wei Wei			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower and OBG		

**Summary of Items Observed:**

This QA inspector performed limited VT of the internal of 43M (top) and 47.6M (top & bottom) of East Tower Lift 1 previously tested and accepted by ZPMC Quality Control personnel. Several of nonconforming discontinuities (cracks and deep gouges) were present at various location of the noted member. QA Inspector Larry Viars had issued an incident report for the noted discontinuities for today's work shift.

Due to limited time in blast shop, VT was not completed on this work shift.

**Bay 7**

SMAW welding of weld joint 005 and 008 located on DP201-016.

Welder is identified as Mr. Wang Hongbo (203206). ZPMC QC is identified as Mr. Chen Chih Chien.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

**Bay 3**

FCAW welding of weld joint 085, 086 and 093 located on FB003-191.

Welder is identified as Mr. Pan Shijun (204338). ZPMC QC is identified as Mr. Liu Wei Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

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FCAW welding of weld joint 021 and 041 located on FB013-046.

Welder is identified as Mr. Ming Liu (044790). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Bay 5

FCAW welding of weld joint 004 located on BK001-016.

Welder is identified as Mr. Fan Xiaoliang (250534). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Bay 10

SAW welding of weld joint 50A located on NSD1-FCSA4-1A/C.

Welder is identified as Mrs. Liu Xiaoyan (207745). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

SAW welding of weld joint 50B located on SSD1-FCSA4-1A/C.

Welder is identified as Mrs. Zhang Lingling (207746). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

FCAW welding of weld joint 23 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Feng Liangjun (040330). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 22 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Yu Jun (201825). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 43 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Wu Zhizhong (057180). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SMAW welding of weld joint 85 located on SSTL3-1B/K.

Welder is identified as Mr. Li Wubin (052915). ZPMC QC is identified as Mr. Su Zhenrong.

The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U2b.

SMAW welding of weld joint 85 located on SSTL3-1B/K.

Welder is identified as Mr. Liu Jianzhen (052892). ZPMC QC is identified as Mr. Su Zhenrong.

The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U2b.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

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**Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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